Work Orde September-14-12			*90209*									Page 1
Revision ID:	D350-607-5			Accept	*N90	0040	1100)*	Setup	Start Stop	1.71	S1*
	Heli-Utility-E 9/12/12 10/12/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Ite Custom							S2*
Approvals:	Process Pla	an: MLJ	Date: /2-09-/)	Tooling: SPC (Y/N):		Date:			Run	Start Stop	1/1	R1* R2*
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool I	D Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
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D350-607-3	Α								4 .	_		
1 \\ \n^ \\ DC \\ Document Control		DOCUMENT CONTROL Memo Photocopy bi	uefile & type labels per PF	0.00 0.00 PPD350-607-543 CHG	IDBR SOUTH STATES	1/2/10/3/		7) a	H M	151	2-10-26
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Packaging												
120 *120* QC Quality Control	*	QC4- 100% Inspect kits f	or completeness	0.00	0A5 15 16.30							

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	CON	FORM	MANCE / UPDATE				
											QA Closed:	Date:	
184 le Ode						DISPOSITION	-		AGAINST	DE	PARTMENT/	PROCESS	•
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	Ш	Centre No	ot Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa		_	Over/Under	 	Temperature/Cure
		Cracks				Broken/Damaged	-	•	ion Incomplete		Part Incorre	 	Weld
4	$\boldsymbol{\vdash}$	Crushed/	Crimped.	-		Burrs	-		ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
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		Heat Trea	it		j	Countersink	1 1	Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

Work Order ID 90209 Page 2 September-14-12 9:49:24 AM Item ID: D350-607-543 Accept *N900040100* Setup Start **Revision ID:** Item Name: Heli-Utility-Basket **Start Date:** 9/12/12 Start Qty: 1.00 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 10/12/12 *1* **Customer:** Reference: Run Process Plan: Tooling: Approvals: Date: Date: Stop Date:_____ SPC (Y/N): OC: Date: Sequence ID/ Operation **Tool ID** Set Up/ Tool # Plan Accept Reject Reject Insp. **Work Center ID Description** Qty **Run Hours** Code Qty Number Stamp Pick Kit 130 0.00 *130* Packaging 0.00 Memo Package as per PPPD350-607-543 Packaging 12/10/31 dd QC21- Final Inspection - Work Order Release 140 0.00 *140* QC 0.00 Memo Quality Control

											DQA:	Date:	*
NCR:	Yes /	/ No				WORK ORDER NON-C	ON	VFORN	ANCE / UPD	ATE	•		
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Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-14-12 9:49:22 AM

Work Order ID:

90209

Parent Item:

D350-607-543

Parent Item Name:

Heli-Utility-Basket

Start Date: 9/12/12

Required Date: 10/12/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC ECN12-535 DD VERF:EC IPP REV:C 12.07.24 AS

EV.A DD VERF BY:EC IPP REV:B 12.03.06 AS PER IPP REV:C 12.07.24 AS PER ECN 12-610 DD VERF:EC

	ECN12-535 DD V	VERF:EC II	PP REV:	C 12.07.2	4 AS PER ECN	12-610 DD V	ERF:EC						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location		Route Seq ID	Unit of Measur	Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350460745111 Quick Release Basket Mor	unting Installation	Manufactured	No			110	Each	5.0000			91.83	33	6
Smo				Location		Loc Qty	<u>I</u>	Loc Code					Sy
2411				FG032		1			<u> </u>				_
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				PK12		3	1						
					87114	1							
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					89087	ŀ							
				PK13	89086	1							
D2690-6 Lanyard Assembly		Manufactured	No		67060	110	Each	30.0000	n P	1	9018	4	
Surface 7 issembly				Location		Loc Qty		Loc Code	(1	
\sim				ST014		26		Loc Code					
SW.					88553	10				T			
					89371	16							
				ST017		4	Ļ						
					86926	4	ļ					1	
D3912-041) Eyebolt Receiver Assemble	y	Manufactured	No			110	Each	14.0000		1	-0		
SM				Location		Loc Qty	<u>I</u>	Loc Code					`
				ST072		14	ŀ						
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D4030-043 Long Basket Assembly, L	ight Lid (350)	Manufactured	No			110	Each	0.0000		891	89 S	V_{-}	
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											DQA:	Date:	
NCR:	⁄es	/ No				WORK ORDER NON-C	ON	NFORI\	MANCE / UPDATE		·		
											QA Closed:	Date:	
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	-	<u></u>				Use-as-is			oforming Finish	<u> </u>	4	e/Packaging	Other
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Material	Н												
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Other	Н			- 4 -									
Process	H												
Supplier	Н												
Training	Н										***		
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Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio September-14-12 9:49:22 AM

Work Order ID:	90209									
Parent Item:	D350-607-543						Start 1	Date: 9/12/12	Required Date: 10/12/12	
Parent Item Name:	Heli-Utility-Basket						Start	Qty: 1.00	Required Qty: 1.00	
D4085-3 Placard, Instructions		Manufactured	No		110	Each	28.0000	1	- 6	
SM				Location ST092 87037 ST095	Loc Oty 4 4 24		Loc Code			
D4086-215 Placard, Max Load		Manufactured	No	87738	110	Each	6.0000	1 1	- W	
SmB				<u>Location</u> ST095 87674	<u>Loc Qty</u> 6 6		Loc Code	87674		
D4151-041 Basket Fwd Hardpoint As	ssembly, Lower	Manufactured	No		110	Each	10.0000	1	S8217 G	
Sm				Location GA ST101 87150 ST103	Loc Qty -4 10 10 4		Loc Code		÷	
Basket Fwd Hardpoint As	ssembly, Upper	Manufactured	No		110	Each	11.0000	1	- Bufo	25
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											DQA:	Date:	1
NCR:	Yes	/ No				WORK ORDER NON-C	CON	NFORM	MANCE / UP	DATE			
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Part i	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	are		Over/Unde	r tolerance	Temperature/Cure
	`	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ect	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

September-14-12 9:49:23 AM

Work Order ID:	90209								
Parent Item:	D350-607-543						Sta	rt Date: 9/12/12	Required Date: 10/12/12
Parent Item Name:	Heli-Utility-Basket						Sta	art Qty: 1.00	Required Qty; 1.00
D4150±041		Manufactured	No		110	Each	21.0000	0	
Attachment Arm Assembl	У								
				Location	Loc Oty		Loc Code		
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				88367	2			8923	<u></u>
				89232	8				-
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AN4±18A) Bolt		Purchased	No		110	Each	1,747.0000	6	
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DQA: _____ Date: ____

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Root				Descri	ption of work order update	Init	ial	Act	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	Eng	Descr	ription	Date	Verification	QC Inspector
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]	Bending			Г	Bend	Пgr	rain		Γ	Ovalized	ſ	Pressure/Forced
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	Crushed/	Crimped.			Burrs	_	•	ions Incomplete/l	Jnclear	Part Lost/M	1	Wrong Stock Pulled
	Cuffs			F	Contamination	\vdash		nance	<u> </u>	Part Moved		
	Heat Trea	ıt			Countersink	\vdash	islabe			Positioned \		
•	Inspection		Tube		Cut Too Short	\vdash	isread		<u> </u>	Power Loss,	r	Other
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Picklist Print

September-14-12 9:49:23 AM

Work Order ID:

90209

Parent Item:

D350-607-543

Parent Item Name:

Nut

Heli-Utility-Basket

Start Date: 9/12/12

Required Date: 10/12/12

Page 4

Start Qty: 1.00

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Loc Code

Loc Code

6,398.0000

Required Qty: 1.00

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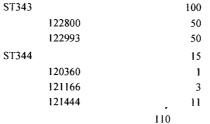
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Location

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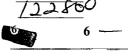




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	121444	13	
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	123021	3000	

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1 10/1/25

NCR: Yes / No													DQA:	Date:	
Work Order: Part No. Part No. Beach of Cause Date Date Description of work order update Equip/Tooling Operator Operator Other Process Stid - tube Machining Small Fab Setup Composite Description of work order update Equip/Tooling Setup Other Description Training Unapproved Date Description Date Verification QC Inspector QC Inspector QC Inspector Description Description Description Date Verification QC Inspector Description Date Verification Process Date Description Date Verification Process Date Description Date Verification Process Date Date Process Date Proce	NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR!	/ANCE / UPD	ATE		·		
Work Order: Part No. Part No. Rework Scrap Use-as-is Use-													QA Closed:	Date:	
Part No.	Mork Orde	or.					DISPOSITION				AGAII	NST DEI	PARTMENT	/PROCESS	•
Part No.	WOIK OIG	٠	-				Rework	7		Skid-tube	Crosst	ube		Water Jet	Engineering
NCR No.	Part f	No.					<u> </u>	1	١	Machining	Small	Fab	Pro	d. Eng. Coor.	Quality
Root Cause Date Step Qty Description of work order update or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling Description Date Verification QC Inspector Operator Doc, Date Date Verification QC Inspector Operator Description Date Verification QC Inspector Operator Date Verification QC Inspector QC Inspector QC Inspector QC Inspector QC Ins		•					Use-as-is]	Therm	noforming	Finish	ning	Rec/Stor	re/Packaging	Other
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Setup Other Process Supplier Training Unapproved Unapproved Unapproved Unapproved Bending Centre Not Concentric to O/S BOM/Route FAULT CATEGORY General Grain Hardware Ovalized Over/Under tolerance Temperature/Cure												•			
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FAULT CATEGORY Landing Gear General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure		_													
Landing Gear Bending Centre Not Concentric to O/S General Grain Grain Hardware Ovalized Over/Under tolerance Temperature/Cure	Unapproved			<u> </u>	<u> </u>	L			T CATE	CORY	****		<u> </u>	<u> </u>	
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Courts Contamination Con		\vdash	•	crimpea.		i i	╡	\vdash	-	•	HUCAI	H	4		Tations stock runed
		\vdash	l					\vdash	-			\vdash	4		
Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other			1.1		Tubo	<u> </u>		\vdash	┥				4		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

September-14-12 9:49:23 AM

Work Order ID:	90209											
Parent Item:	D350-607-543							Star	Date: 9/12/12	Re	equired Date: 10/12	2/12
Parent Item Name:	Heli-Utility-Basket							Star	t Qty: 1.00	R	equired Qty. 100	
MS24665-151 Cotter Pin		Purchased	No			110	Each	303.0000		1	-()	
	\wedge			Location	1	Loc Qty		Loc Code				
/ Sx	1,)			ST309		103				_		
					17566	103				_		
				ST323		200				_	_	
					122802	200			122802			
ASISISHAL ASHER		Purchased	No			110	Each	367.0000	2	2 —		
				Location	1	Loc Qty		Loc Code				
$\sim \sim$				FG		8						
Shop					103691	8				_		
/				ST277		359				_		
					118709	2			10 - 2	€ \		
					120390	357			1203		1	
NAS1149F0432P- Washer	/-	Purchased	No			110	Each	978.0000	12	12 <		8/
				Location	1	Loc Qty		Loc Code				
Sms				275		594				_		
200					122441	594			<u> </u>			
				ST275		384				_		
					121350	15			10115	†		
					122151	369			12110	<u>/</u>		
VAS1149G0463R Washer		Purchased	No			110	Each	666.0000	310	3 /	/ Us/1/20	5
				Location	ļ	Loc Qty		Loc Code				
				FP001		1				_		
					115358	1				_		
5m0				ST297		665				_		
- 1.					117735	17			110.0	- 1		
					119097	648			11707	_/		

											DQA:	Date	: v * _
NCR: \	/es	/ No				WORK ORDER NON-C	O	NFORN	ANCE / UPDATE		•		
									·		QA Closed:	Date	:
Work Orde						DISPOSITION			AGA	INST DEI	PARTMENT	/PROCESS	•
WORK OTGE	٠. <u>-</u>		•			Rework	1		Skid-tube Cross	tube		Water Jet	Engineering
Part N	۰ No.					Scrap Use-as-is		ľ	Machining Small			d. Eng. Coor.	Quality
NCR N	۰ lo.					Work Order Update		i .	Large Fab Compo	~⊢⊣	Nec/Stol	Supplier	
Root					Descri	ption of work order update	I	nitial	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data						•							
Equip/Tooling													
Operator													
Material													
Setup	Ш												
Other]										
Process				0									
Supplier				,			ĺ						
Training					,				<u></u>				
Unapproved													
					,	F	AUL	T CATE	GORY				
Landi	ng G	ear				General				_	•	-	
	Ш	Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	L	4	on Incomplete		Part Incorre	ct	Weld
*		Crushed/	Crimped.			Burrs	L	Instruct	ions Incomplete/Unclear		Part Lost/M	issing	Wrong Stock Pulled
	Ш	Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	it			Countersink		Mislabe	led		Positioned \	Nrong _	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss,	/Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Outside Dimensions

Out of Sequence

Turning Sequence

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REFERENCE ONLY

DART AEROSPACE LTD.

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4.0 WEIGHT AND BALANCE

Installation	Weight	LA	TERAL	LONG	ITUDINAL
		Arm	Moment	Arm	Moment
D350-607-541	80.7 lb	± 49.1 in	± 3962 in-lb	135 in	10895 in-lb
(Standard Basket)	36.6 kg	± 1.25 m	± 45.8 m-kg	3.43 m	125.5 m-kg
D350-607-543	65.7 lb	± 49.1 in	± 3226 in-lb	135 in	8870 in-lb
(Lightweight Basket)	29.8 kg	± 1.25 m	± 37.3 m-kg	3.43 m	102.2 m-kg
D350-607-545	58.7 lb	± 49.1 in	± 2882 in-lb	135 in	7925 in-lb
(Standard Basket)	26.2 kg	± 1.25m	± 32.8 m-kg	3.43 m	89.9 m-kg
D350-607-547	47.7 lb	± 49.1 in	± 2342 in-lb	135 in	6440 in-lb
(Lightweight Basket)	21.6 kg	± 1.25 m	± 27.0 m-kg	3.43 m	74.1 m-kg
D350-607-511 (Quick Release Basket Mounting Kit)	7.2 lb 3.3 kg	± 36.9 in ± 0.94 m	± 266 in-lb ± 3.1 m-kg	135 in 3.43 m	972 in-lb 11.3 m-kg

5.0 PARTS LIST

QTY	(QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-541	543	-545	-547	-511	-501		
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		Х				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	VIII	1_		x=		ED350-607-511====	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
							"LANYARD=
1	-1	1	1		1	D2690-6	
				4	4	D3910-3	X-TUBE LUG
1					1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
						:D4030-043	LONG BASKET-ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1	===	1	1		===	D4085-3	*PLACARD-INSTRUCTIONS
1					11	D4086-200	PLACARD, MAX LOAD
	45	1			-	*D4086-215	≠PLACARD, MAX LOAD
		1			1	D4086-220	PLACARD, MAX LOAD
			1		1	D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	_1		-	THE PLANT CO.	1	D4150-041	ATTACHMENT ARM ASSY
1	Ĭ	1		-	1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1			1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
6	~6=	==6==	<u>6</u>		<u>=6=</u>	-AN4-13A	-BOLT
				16	16	AN4-14A	BOLT
1	_1	1	1		==1==	FAN4C15	FBOLT
1			1_		1	FAN310C4	-CASTELLATED NUT
			1_		1	-MS17984-C413	FQUICK RELEASE PIN
6	26 =		-6	=16=	= 22	MS21042L4	-NUT (OR MS21042-4)
1		=1=1	1			MS24665-151	COTTER PIN
	2-		2		-2-	-NAS1515H4L	-WASHER
12			12 ==	-32-	-44-	-NAS1149F0432P	-WASHER-
3		- 3	3.1.	·	3		-WASHER

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Revision: A

Date: 10.06.28